

Date: Wednesday, 3/14/2007 3:31:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LUG ASSEMBLY	
Job Number	31225 -2		Part Number	D27361	
Estimate Number	10011		Drawing Number	D2736 REVA	
P.O. Number	N/A		Project Number	N/A	
This Issue	3/14/2007 S.O. No. N/A		Drawing Revision	A	
Prst Rev.	NC		Material	N/A	
First Issue	3/14/2007 Type: LARGE FAB ASSY		Due Date	4/6/2007	
Previous Run	29783		Qty:	40	Um: Each
Written By					
Checked & Approved By					
Comment	Est Rev:D Removed from 9 digit 05-10-25 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2591	Lug	(40)
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s) 031231	FC 07 05 29
		Pick: Batch 031231X20	(40)
		Qty Part Number Description 1 D2591 Lug	Batch 031231X20
2.0	D27351	Lug Bracket	(40)
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s) 031235	FC 07 05 29
		Pick: Batch 031235X15	(40)
		Qty Part Number Description 1 D2735-1 Lug Bracket	Batch 031235X15
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484 Steel Rod Batch: M10394	FC 07/05/29 (40)
4.0	QC9	VISUAL WELDING INSPECTION	(40)
		Comment: VISUAL WELDING INSPECTION	AA 07/05/29 (40)
5.0	QC5	INSPECT WORK TO CURRENT STEP	(40)
		Comment: INSPECT WORK TO CURRENT STEP	AA 07/05/29 (40)

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Drawing Name: LUG ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(40X)

m 103 141

BR/a.m

07-05-30

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(40X)

M-1

07/05/31

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

Final Inspection/W/O RELEASE

(40)

9.0 QC21



Comment: FINAL INSPECTION/W/O RELEASE

R.07/06/01

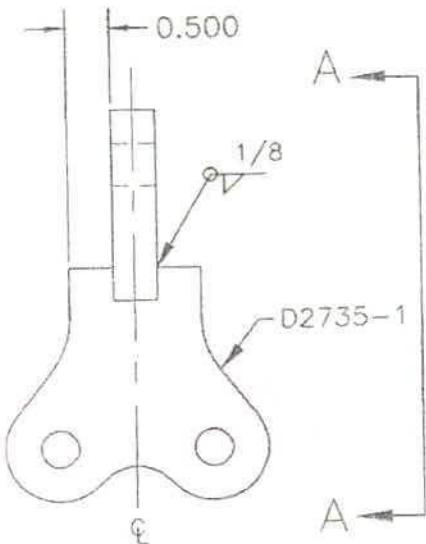
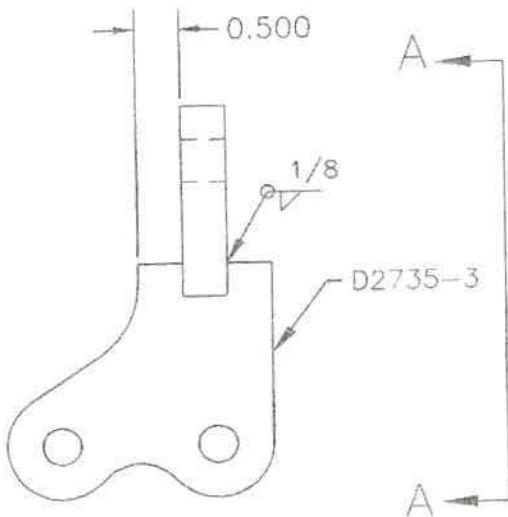
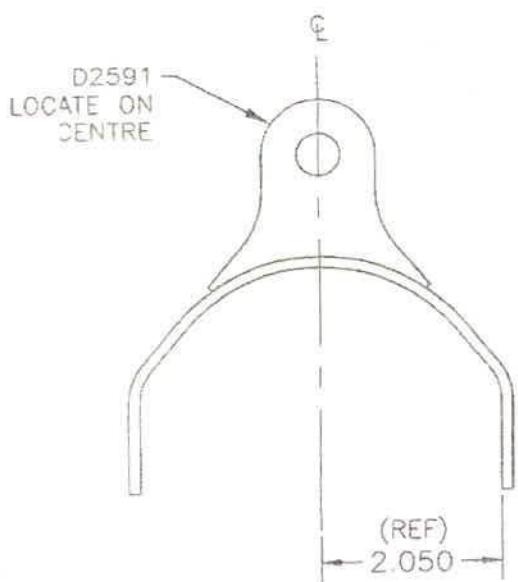
Job Completion



107/06-01

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>RE</i>	APPROVED <i>JF</i>	DRAWING NO. D2736
DATE 97.12.18		TITLE LUG ASSEMBLY
A	97.12.18	SCALE NTS
		NEW ISSUE

D2736-1 LUG ASSEMBLYD2736-3 LUG ASSEMBLYVIEW A-ANOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

RELEASED
 97/12/24 D, **COPY**
 CCW 457, **REF TO**
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 31225